



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

RBE350A93-3303-02

Job Sheet 180017



006579

DAS
21
9-89

Part No: RBE350A93-3303-02

Job Qty: 5

Part Name: Tail Rotor Head Body Extractor Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/27/18

Job Tracking No:

Due Date: 8/20/18

Created By: Logan David

Type: SOLD

Description:

Note: RBE350A93-3303-02 REV 4 IPP REV A 18-01-17 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	5 pcs	8/20/18	8/20/18	0.08	5.00	Small Fab-9		MLL DAS
110	QC	5 pcs	8/20/18	8/20/18	0.00	0.00	QC5		NOV 21 2018 68
130	Packaging	5 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-2		MLL 9-89
140	QC21-FG	5 Ea	8/20/18	8/20/18	0.00	0.00	QC21		NOV 21 2018

Part Op 100 - Assemble as per DWG. Sheet 1 - Loctite 263 B M138904 Exp: 4/20

Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91030A031	Flange Hex Nut	10 Ea (2 ea)	90-Start up Operation	31050896 3105084061
RBE350A93-3303-02-1	Receiver	5 Ea (1 ea)	90-Start up Operation	3109790
RBE350A93-3303-02-3	Extractor	5 Ea (1 ea)	90-Start up Operation	3109798
RBE350A93-3303-02-5	Extractor Pin	5 Ea (1 ea)	90-Start up Operation	3079438
RBE350A93-3303-02-7	Stud	10 Ea (2 ea)	90-Start up Operation	3102649

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91030A031	10	39	0
	RBE350A93-3303-02-1	5	6	0
	RBE350A93-3303-02-3	5	6	0
	RBE350A93-3303-02-5	5	81	0
	RBE350A93-3303-02-7	10	12	0



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Part Specifications

not be found.

Container No: S129754



Part: RBE350A93 - 3303 - 02

Job No: 180017

Serial No/Batch: S129754

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 11/21/18

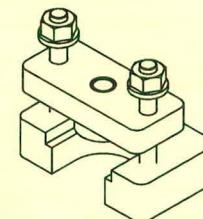
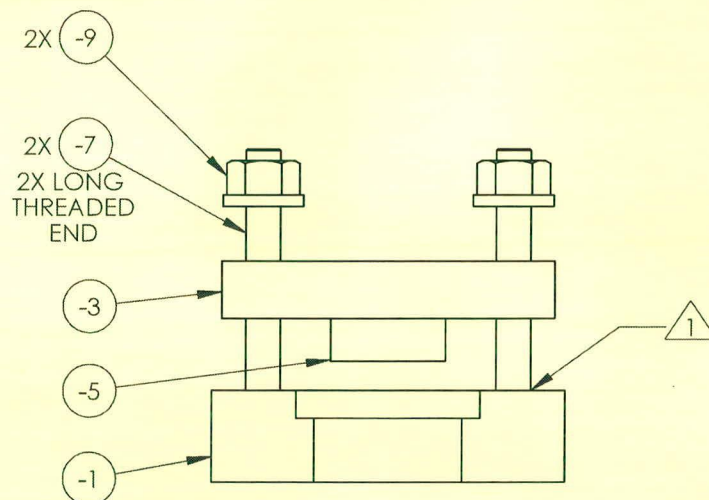
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D FROM HEX BOLTS & SET SCREWS TO STUDS. -1 ADDED R.25 TO CORNERS. -3 CH'D HOLES FROM Ø.413 AND ADDED R.25 TO CORNERS.	12/4/2008	WP	DW
2		-11 ADDED LOCTITE TO BOM. -5 ADDED .03 X 45° CHAMFER.	12/4/2008	WP	DW
2A		CORRECTED T/N AND TOOL NAME WAS RBEA93-3303-02, T/R HUB BODY EXTRACTOR TOOL IS RBE350A93-3303-02, T/R BODY EXTRACTOR TOOL.	11/5/2013	RJC	RW
3		-3 CH'D DIMS WAS Ø.500 IS LIMITS Ø.5000 - .5005, WAS .630 IS (.625). -5 CH'D DIM WAS Ø.501 IS Ø.5010 - .5015. -9 CH'D WAS SWIVEL HEX NUT #90477A031 IS FLANGE HEX NUT #91030A031.	3/13/2014	DPD	GE
4	15-0132	-1 & -3 CH'D MATERIAL WAS 1018 IS A36/1018/1020. -5 CH'D MATERIAL WAS 4140 G&P IS 4140/4142 Q&T.	6/10/2015	RJC	JAG



NOTE:

1 2X LOCTITE ON THREADS -7 TO -1.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	A36/1018/1020		2
			-3	1	EXTRACTOR	A36/1018/1020		3
			-5	1	EXTRACTOR PIN	4140/4142 Q&T		4
			-7	2	STUD	STEEL	3/8-16 UNC-2A X 4 (MCMASTER-CARR #90281A640) MODIFIED	5
		B/O	-9	2	FLANGE HEX NUT	STEEL	3/8-16 UNC-2B (MCMASTER-CARR #91030A031)	1
		B/O	-11	AR	262 LOCTITE		(MCMASTER-CARR #91458A180)	N/S

DART AEROSPACE	
TITLE T/R BODY EXTRACTOR TOOL	
DWG NO. RBE350A93-3303-02	REV 4
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER AS350A
SCALE 1:2	DATE 10/27/2008 SHEET 1 OF 5

